

Work Order ID 144414

April 15, 2016 4:00:23 PM

144414

Page 1

Item ID: D4785-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Long Basket Base Assembly, LH/RH

Start Date: 5/30/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

SK

Date:

20160414

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4785

B

100

Weld per dwg A/R S.S. rod Batch: **133750** 0.00***100***

Large Fab

Large Fab

Large Fab

Memo

3.12

1- Use DT9610A to assemble contour ribs and the (2) D3916-5 ribs , weld as per dwg D4785

inspect before welding mesh

ENSURE BOTTOM OF BASE RIB ARE STRAIGHT

2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D4785 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends

USE DT10158 WITH SHIM WHEN WELDING BOTTOM OF RIB D4785-115

ENSURE BOTTOM OF BASE RIB ARE STRAIGHT

3- weld hinge (3) and Mounting brackets as per dwg D4785

take lid to locate hinge and bracket

4- Weld D4672-1 blanking plates as per dwg

ENSURE BOTTOM OF BASE RIB ARE STRAIGHT

1x CC 16.5.19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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April 15, 2016 4:00:23 PM

144414

N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

Cust Item ID:

Start Date: 5/30/2016 **Start Qty:** 1.00

Required Date: 6/17/2016 **Req'd Qty:** 1.00

1

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------------	---------------	------------------	----------------

0.00

DAS

110

0.00

9

QC

Memo

*****ENSURE BOTTOM OF BASE RIB ARE STRAIGHT*****
Use DT10160 jig to ensure D4785-115 holes are align after welding

Quality Control

0.00

DAS

120

0.02

9

OC

Memo

*****ENSURE BOTTOM OF BASE RIB ARE STRAIGHT*****
Use DT10160 jig to ensure D4785-115 holes are align after welding

Quality Control

0.00

0-89 34 DAS

125

1.07

HandFinish

Memo

Hand Finishing

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 144414

April 15, 2016 4:00:23 PM

144414

Page 3

Item ID: D4785-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Base Assembly, LH/RH
 Start Date: 5/30/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/17/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo 1- Plug holes and mask only interior of hinge (3) prior to powder coat <i>M 134631</i> 1ST COAT: <i>7:30</i> START TIME: <i>7:30</i> OVEN TEMPERATURE: <i>1400°</i> FINISH TIME: <i>8:00</i> ***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.66				<i>1</i>	<i>0</i>	<i>16-05-26</i>	<i>29 34 9:09</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01							<i>12 of 14 16/05/2016</i>

DAS
15
9:09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Page 4

Item ID: D4785-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Long Basket Base Assembly, LH/RH

Start Date: 5/30/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Assemble as per dwg	0.00							
150		0.41							
HandFinish									
Hand Finishing	<u>Memo</u> Pick kit and assemble								
		MAY 24 2016							
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC		0.02							
Quality Control	Memo								
									DAS 38 9-89 MAY 27 2016
170	Identify as per dwg & Stock Location: <u>w/o</u>	0.00							
170									
Packaging		0.01							
Packaging	Memo								
									D 4784-011/ B144413 14 4/ 16/05/24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21 - Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.10							
Quality Control									

MC

MAY 27 2016

MC

MAY 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																															
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Page 1

Work Order ID: 144414

144414

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.03.14 NEW ISSUE DD VERF:JLM
REV:B 13.06.17 as per dwg rev.pb1 DD VERF:JLM
13.07.04 revise bom per dwg rev.B DD VERF:JFS
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4785-1		Manufactured	No			100	Each	4.0000	2	2			
D4785-1									**			CC 16-5-19	
Rib													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA004	4							
					133295	4							
D4785-5		Manufactured	No			100	Each	9.0000	3	3			
D4785-5									**			CC 16-5-19	
Rib													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA004	9							
					121284	3							
					133297	6							
D4785-115		Manufactured	No			100	Each	0.0000	4	4			
D4785-115												CC 16-5-19	
Rib Assembly													
D4785-117		Manufactured	No			100	Each	0.0000	2	2			
D4785-117												CC 16-5-19	
Rib Assembly													
D4785-3		Manufactured	No			100	Each	4.0000	2	2			
D4785-3									**			CC 16-5-19	
Rib													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA004	4							
					133300	4							

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Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

D4017-7

Manufactured No

100 Each 9.0000 3 3

D4017-7

Rib

**

CC 16-5-19

Location

Loc Qty

Loc Code

WA004

9 B142378

142415

6

143985

3

3x

D4034-041

Manufactured No

100 Each 4.0000 1 1

D4034-041

Aft Upper Rib Assembly

**

CC 16-5-19

Location

Loc Qty

Loc Code

WA004

4 B146167

141918

1

142374

3

1x

D4034-043

Manufactured No

100 Each 4.0000 1 1

D4034-043

Fwd Upper Rib Assembly

**

CC 16-5-19

Location

Loc Qty

Loc Code

WA004

4 B146168

141919

1

142375

3

1x

D3916-5

Manufactured No

100 Each 3.0000 2 2

D3916-5

Light Rib

**

CC 16-5-19

Location

Loc Qty

Loc Code

WA004

3 B145200

142370

3

2x

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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 4

Work Order ID: 144414

144414

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

D4672-1

Manufactured No

150

Each

25.0000

2

2

LC 16-5-19

D4672-1

Blanking Plate

Location

Loc Qty

Loc Code

WA004

25

141229

25

100

Each

7.0000

2

2

142656

DAS

6

9-89

D4021-5

Manufactured No

D4021-5

Blanking Plate

Location

Loc Qty

Loc Code

ST071

7

137592

6

177489bk

1

100

sf

368.0000

33

33

LC 16-5-19

M304EX0.75-16F

Purchased

No

M304EX0 75-16F

Expanded Metal Flat SS

Location

Loc Qty

Loc Code

WA004

368

M133868

25

M134184

110

M134331

233

100

Each

31.0000

2

2

LC 16-5-19

D4020-11

Manufactured No

D4020-11

End Mesh, Basket

Location

Loc Qty

Loc Code

WA004

31

130247

4

142361

27

2x

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Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
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OTHER : ☐																									

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Work Order ID: 144414

144414

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

D4016-1

Manufactured No

100

Each

33.0000

3

3

D4016-1

Hinge Half, Base

**

CC 16-5-19

Location

Loc Qty

Loc Code

WA004

33

140745

33

D2931

Manufactured No

150

Each

1,599.000

2

2

D2931

Bumper

**

DAG
8-89

MAY 24 2016

Location

Loc Qty

Loc Code

ST013

76

86435

76

ST025A

1523

86435

1523

D2581

Manufactured No

100

Each

82.0000

2

2

D2581

Mounting Bracket

**

CC 16-5-19

Location

Loc Qty

Loc Code

WA004

82

132771

1

136270

2

139082

11

141097

20

142787

48

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Work Order ID: 144414

144414

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-10A Purchased No 150 Each 269.0000 6 6

AN3-10A

Bolt

Location	Loc Qty	Loc Code
GA	1	
m132763	1	
over003	100	
m134249	100	
ST349	168	
m133992	68	
m134573	100	

MS20600-AD4W3 Purchased No 150 Each 430.0000 2 2

MS20600-AD4W3

Cherry Rivets

Location	Loc Qty	Loc Code
GA	160	
m129795	160	
ST308	186	
m133316	24	
m134167	162	
WA003	84	
m130018	84	

MAY 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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Picklist Print

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Work Order ID: 144414

144414

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

1,784.000

6

6

MS21042L3

Nut

DAS

6

9.89

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

786

m133790

3

m134360

783

ST304

898

m134039

12

m134360

886

6

NAS1149DN832J

Purchased

No

150

Each

1,801.000

2

2

NAS1149DN832J

Washer

DAS

6

9.89

Location

Loc Qty

Loc Code

CA

84

M129499

84

ST265

1717

M131697

220

M134180

1497

2

NAS1149F0332P

Purchased

No

150

Each

1,915.000

12

12

NAS1149F0332P

Washer

DAS

6

9.89

Location

Loc Qty

Loc Code

GA

312

m133709

312

ST262

1603

m134134

103

m134257

1500

12

MAY 24 2016

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Shop Packet Print

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DQA: _____ Date: _____



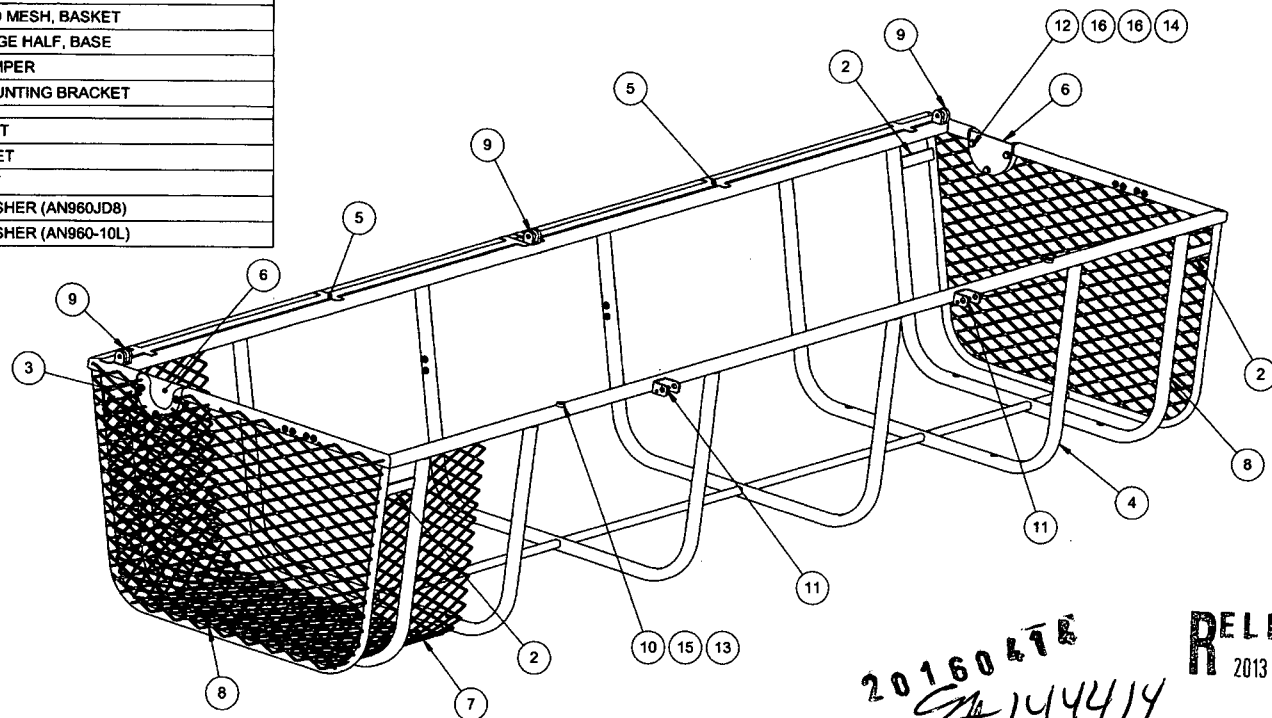
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
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		OTHER : ☐			

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4785-041	LONG BASKET BASE ASSY, LH/RH
2	3	D4793-1	HANDLE PLATE
3	1	D4793-3	WIDE HANDLE PLATE
4	1	D4785-101	TUBULAR ASSEMBLY, LH/RH
5	2	D4672-1	BLANKING PLATE
6	2	D4021-5	BLANKING PLATE
7	1	D4020-1	MESH BASKET LONG, BASE
8	2	D4020-11	END MESH, BASKET
9	3	D4016-1	HINGE HALF, BASE
10	2	D2931	BUMPER
11	2	D2581	MOUNTING BRACKET
12	6	AN3-10A	BOLT
13	2	MS20600AD4W3	RIVET
14	6	MS21042L3	NUT
15	2	NAS1149DN832J	WASHER (AN960JD8)
16	12	NAS1149F0332P	WASHER (AN960-10L)



D4785-041 LONG BASKET BASE ASSY, LH/RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 50.42 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2013-06-20

20160478
SA144414

B	REPLACE D3916-5 WITH D4785-117 (ZN B5-4, B4-4, B5-7); REVISE D4785-5 DIMENSION (ZN B5-5)	RF	13.06.11
A	NEW ISSUE	RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4785 TITLE LONG BASKET BASE ASSY DATE 13.06.11	
DRAWN	RF		
CHECKED	DC		
MFG. APPR.	AS		
APPROVED	AS		
DE APPR.	AS	SHEET 1 OF 7 SCALE NTS	
COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

TRIM MESH LOCALLY
Ø0.50 - Ø0.60
TO CLEAR BUSHINGS
TYP

D4021-1
MESH



TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2

0.75

A
B7-3

D4785-041 LONG BASKET BASE ASSY, LH/RH
(MESH SHOWN LOCALLY FOR CLARITY)

14 PL
(AROUND TAB, TYP
AND AT BTH ENDS)

0.76
TYP

D4672-1
BLANKING PLATE
2 PL

D4785-101
TUBULAR ASSY

D2931 BUMPER
NAS1149DN832J WASHER
MS20600AD4W3 RIVET
2 PL 8

D2581
MOUNTING BRACKET
2 PL

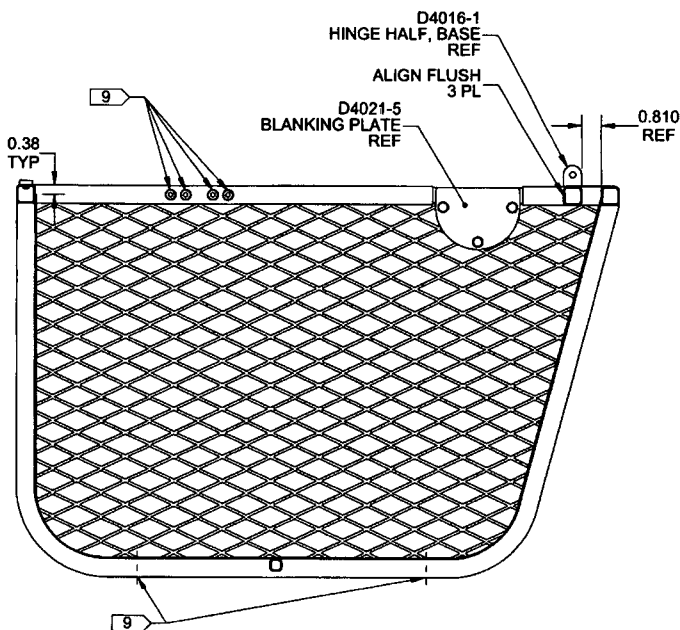
D4016-1
HINGE HALF, BASE
3 PL

D4793-3
HANDLE PLATE
LOCATED ON BASKET
BACK SIDE

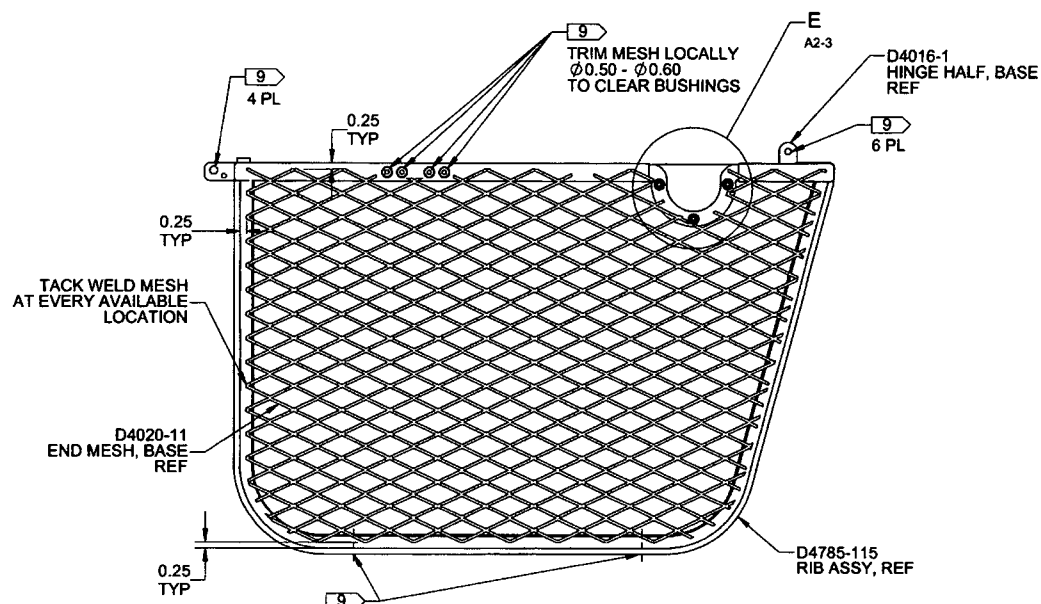
D4793-1
HANDLE PLATE
3 PL

RELEASED
2013-06-20

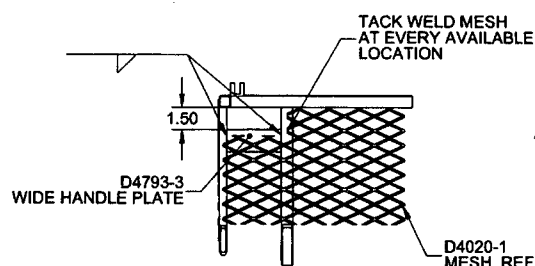
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	S	D4785	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY	NTS
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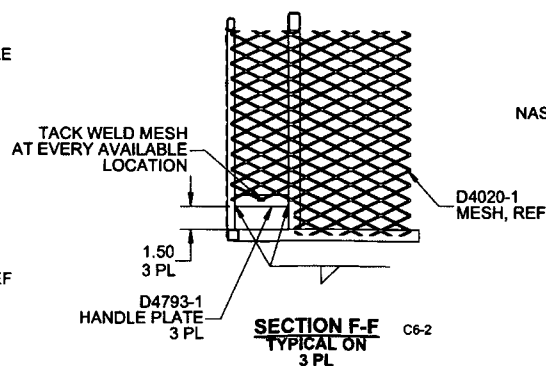
SECTION A-A B7-2



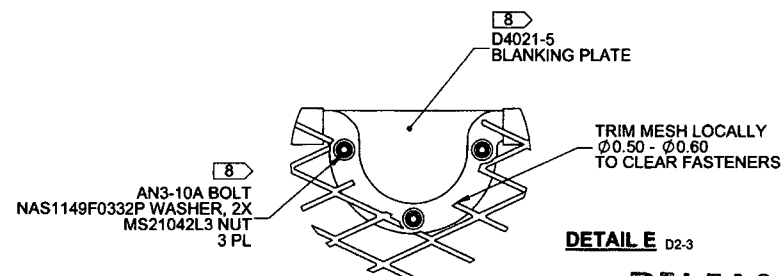
SECTION VIEW B-B A2-2



SECTION D-D D6-2



SECTION F-F C6-2
TYPICAL ON 3 PL

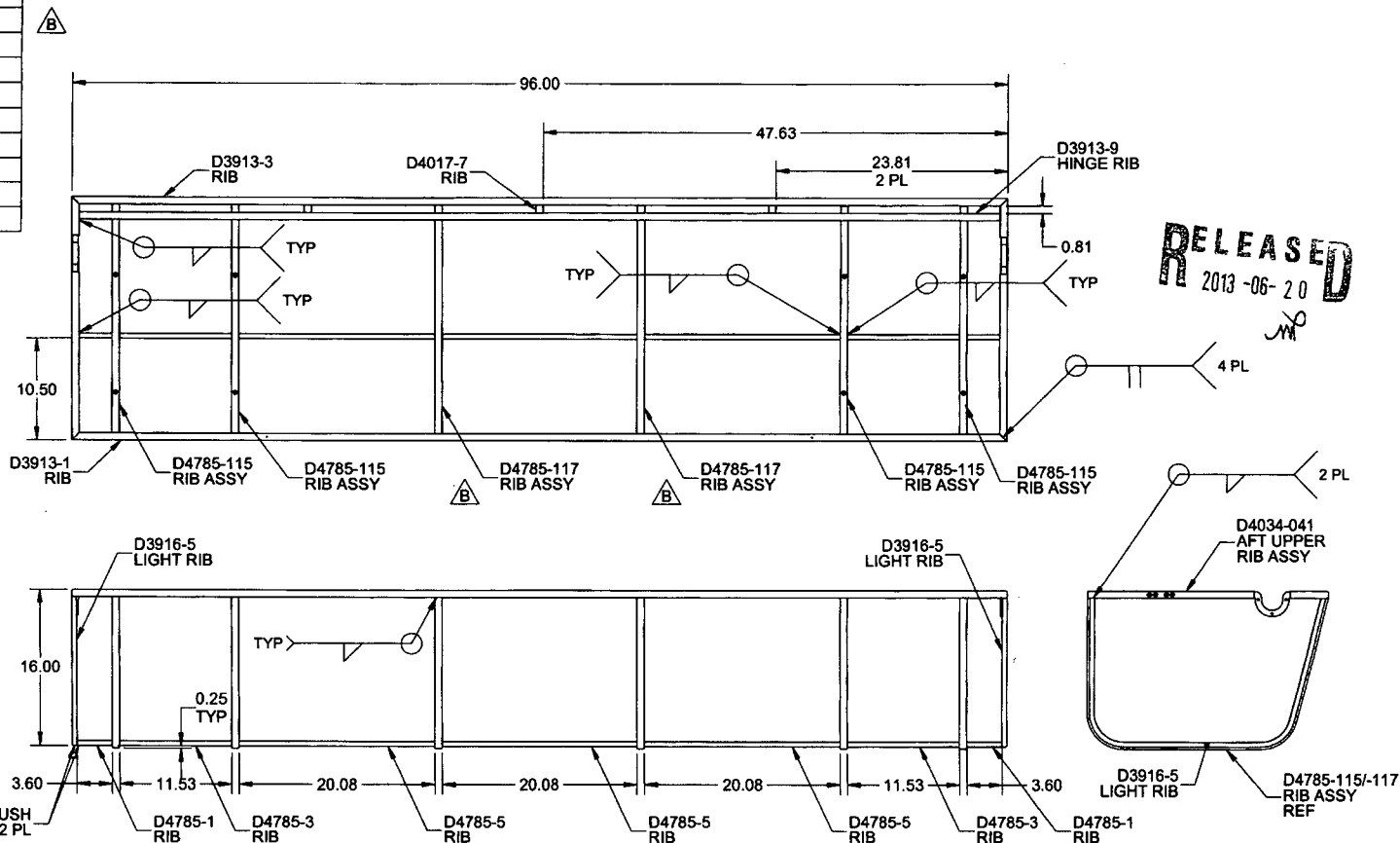


DETAIL E D2-3

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	N	D4785	SHEET 3 OF 7
APPROVED	N	TITLE	SCALE
DE APPR.	N	LONG BASKET BASE ASSY	NTS
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ITEM NO.	QTY. -101	PART NUMBER	DESCRIPTION
1	X	D4785-101	TUBULAR ASSEMBLY
2	2	D4785-1	RIB
3	3	D4785-5	RIB
4	4	D4785-115	RIB ASSEMBLY
5	2	D4785-117	RIB ASSEMBLY
6	2	D4785-3	RIB
7	3	D4017-7	RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY
10	2	D3916-5	RIB, LIGHT
11	1	D3913-1	RIB
12	1	D3913-3	RIB
13	1	D3913-9	HINGE RIB

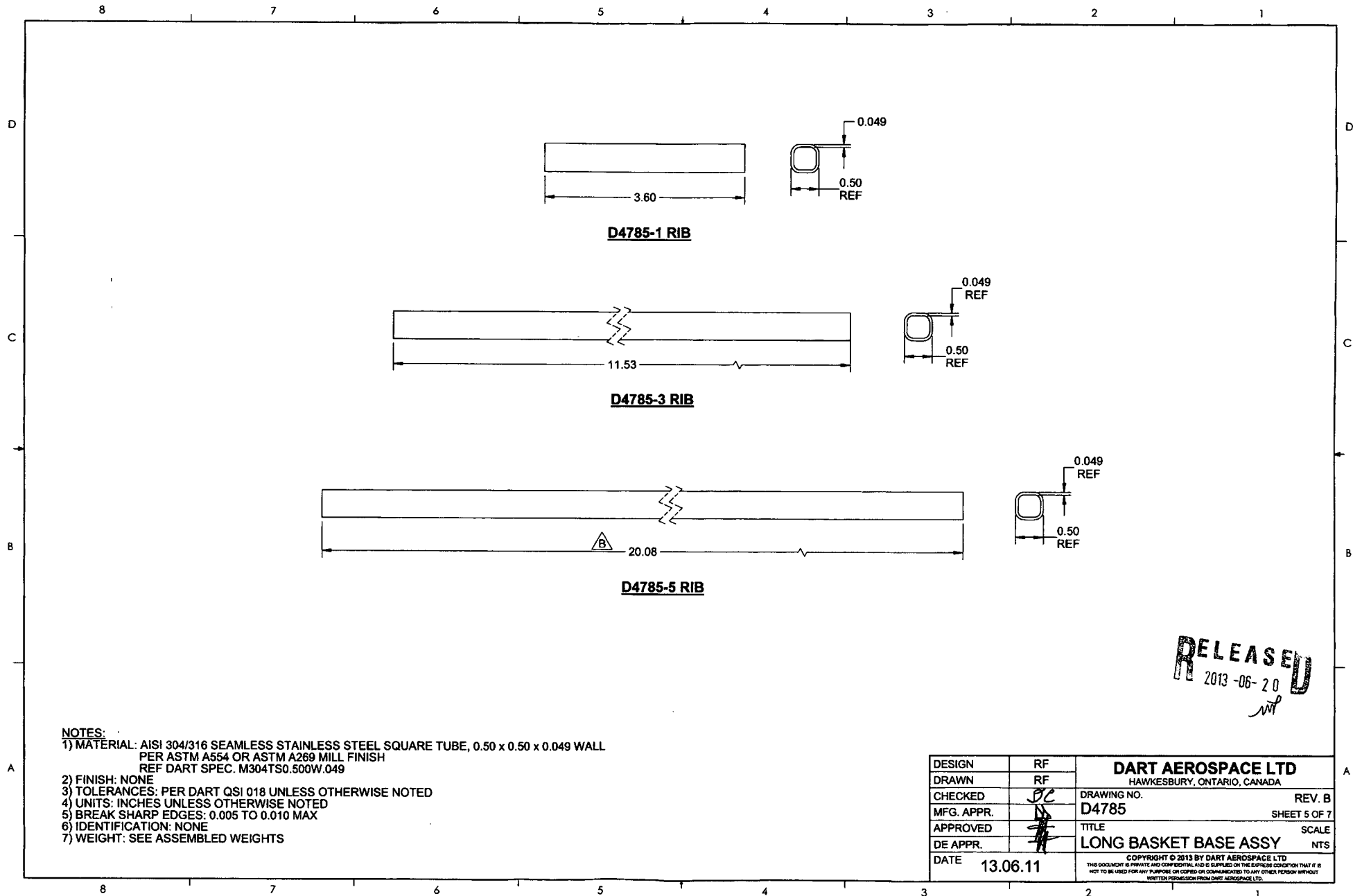


NOTES:

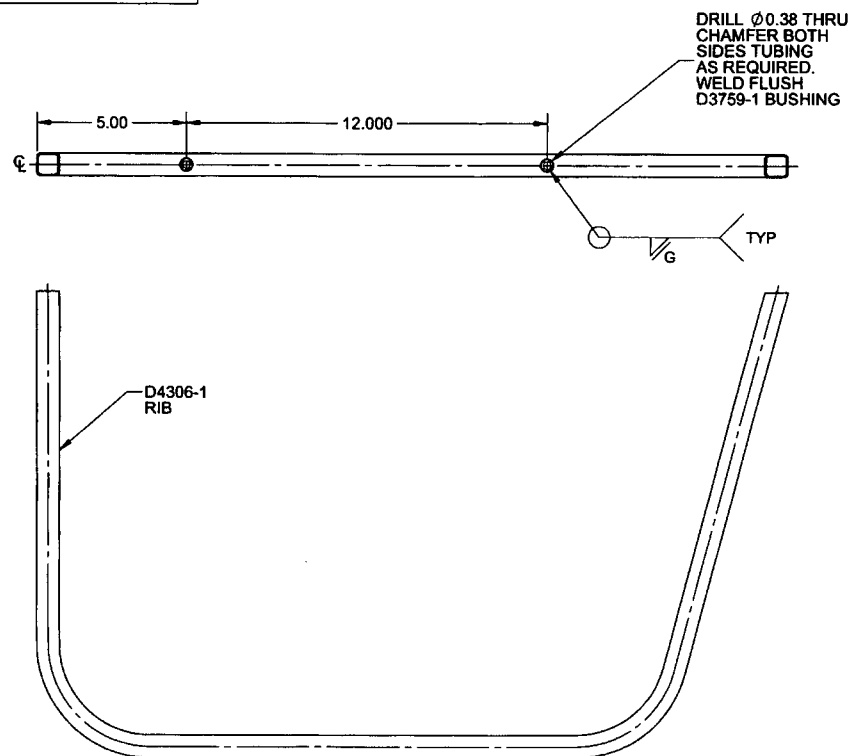
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.65 lbs
- 8) WELD PER DART QSI 004

D4785-101 TUBULAR ASSEMBLY, LH/RH

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D4785	SHEET 4 OF 7
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET BASE ASSY	NTS
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ITEM NO.	QTY. -115	PART NUMBER	DESCRIPTION
1	X	D4785-115	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D3759-1	BUSHING



D4785-115 RIB ASSEMBLY
MAKE FROM D4306-1 RIB

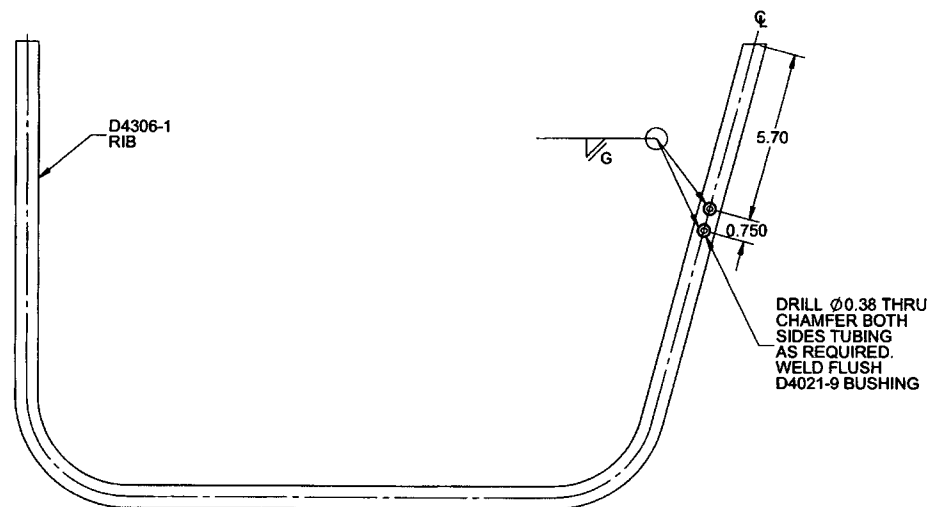
RELEASED
2013-06-20
JMD

NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.80 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	N	D4785	SHEET 6 OF 7
APPROVED	N	TITLE	SCALE
DE APPR.	N	LONG BASKET BASE ASSY	NTS
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ITEM NO.	QTY. -117	PART NUMBER	DESCRIPTION
1	X	D4785-117	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D4021-9	BUSHING



D4785-117 RIB ASSEMBLY 
MAKE FROM D4306-1 RIB

NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs
- 8) WELD PER DART QSI 004

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DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4785	SHEET 7 OF 7
APPROVED		TITLE	SCALE
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